Finished Products  Epoxy Resin Transfer Molding

Product—Duratec® Vinyl Ester In-Mold Primer (1794-034 White, 1799-034 Gray)

Duratec Vinyl Ester In-Mold Primer is used as an in-mold primer for parts made with epoxy laminating resin. This Duratec primer has great adhesion to the laminate. The primer eliminates pre-release and alligatoring in thin films. Using the Duratec primer as an in-mold surface coating will eliminate porosity and pinholing and provide a surface that is easily prepared for topcoating.

1 Application Conditions—Mold surfaces should be prepared with the proper release agents. Ambient temperatures should be in excess of 68°F, 20°C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77°F, 25°C.

Note: Many release systems will work. We’ve seen success with Axel, TR, and Chemtrend. Here are links to their websites:

Axel, [http://www.axelplastics.com](http://www.axelplastics.com)
TR [http://www.trindustries.com](http://www.trindustries.com)
Chemtrend, [http://www.chemtrend.com](http://www.chemtrend.com)

2 Thoroughly stir Duratec Vinyl Ester In-Mold Primer in the can prior to catalyzing—any fillers must be mixed completely into the liquid. Due to the rapid gel time of the primer, mix only the amount that can be applied within 14 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures yield a longer pot life and gel time.) Catalyze at 2 percent by volume with full strength mekP catalyst (20 cc per quart) for a 14 minute pot life.

Note about drums: With relatively low viscosity, Duratec Vinyl Ester In-Mold Primer requires frequent gentle agitation in the drum with a variable-speed, air-driven mixer with 12” diameter mixing blades.

3 On a properly prepared mold, spray catalyzed Duratec Vinyl Ester In-Mold Primer using the same spray equipment used to spray gel coats, or siphon or pressure pot spray system. Spray from 15-20 mils, 375-500 microns thickness and after 3 minutes lay in the reinforcement, close the mold and inject the resin. After demolding, sand the primed surface in preparation for the topcoat paint system.

SAFETY PRECAUTIONS: Duratec Vinyl Ester In-Mold Primer is extremely flammable. Do not apply near sparks, open flame or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Do not take internally.

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